



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3213-1
Job Sheet 185962



Part No: D3213-1

Job Qty: 4 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 05-11-17 New Issue JLM IPP Rev:B 07-02-13 Now on Waterjet JLM IPP Rev C:
08.11.26 Comment added to step 2 KJ Verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	11/29/18	11/29/18	0.00	0.31	Waterjet - Flow		SC DAS 11/1/18
120	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC8		38
130	Small Fab	4 pcs	11/29/18	11/29/18	0.00	0.00	Small Fab-3		9-89
140	HandFinish	4 pcs	11/29/18	11/29/18	0.00	0.19	HandFinish1		D.R. 11/1/20
150	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC3 0.7		38
160	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3 5484		NOV 29 2018
170	QC21-SA	4 Ea	11/29/18	11/29/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-Cut as per Dwg D3213
Descriptions: 130 - Deburr

NOV 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	1.8856 sf (.4714 ea)	100-Waterjet - Flow - 1	SC 66-326

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	2	115	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	15.000inches $\pm$ 0.030	15.030 14.970	15,000	
2	Door Panel	4.470inches $\pm$ 0.030	4.500 4.440	4,473	
3	Door Panel	14.400inches $\pm$ 0.005	14.405 14.395	14,400	
4	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,301	
5	Door Panel	0.128inches + 0.005 - 0.001	0.133 0.127	0,131	
6	Door Panel	2.057inches $\pm$ 0.005	2.062	2,060	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐					
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																					
Description Work Order Disposition				Disposition																					
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 613 632-8200 Email: sales@dartaero.com www.dartaero.com Date: 11/16/18 Container No: S128516 Part: D3213-1 Job No: 185962 Serial No/Batch: S128516 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	ORY <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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